



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE105-40001W1-5
Job Sheet 171958-A



Part No: RBE105-40001W1-5

Job Qty: 3 ea

Part Name: Retaining Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/22/18

Job Tracking No:

Due Date: 4/23/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG RBE105-40001W1 Rev A IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC	3 pcs		4/23/18	0.00	0.00	QC2 Machining-4		
130	QC	3 pcs		4/23/18	0.00	0.00	QC8 Machining-4		
140	Packaging	3 pcs		4/23/18	0.00	0.00	Packaging3-1		
150	QC21-SA	3 Ea		4/23/18	0.00	0.00	QC21		

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 5/22/18 10:20 AM dart.leroux.jason



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RBE105-40001W1-5
Job Sheet 171958



Part No: RBE105-40001W1-5

Job Qty: 1 Ea

Part Name: Retaining Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-40001W1 Rev A IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/15/18	0.00	0.00	Start Up Machining-2		
110	Mori Seiki	4 pcs		2/16/18	0.00	2.00	MORI SL2500Y		
120	QC	4 pcs		2/16/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs		2/16/18	0.00	0.00	QC8 Machining-4		
140	Packaging	4 pcs		2/16/18	0.00	0.00	Packaging3-1		
150	QC21-SA	4 Ea		2/16/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Machine as per folio FB 909 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.500	17-4 SS Round Bar (H900 Condition)	.4000 ft (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.500	0	0	0

Part Specifications

Specifications could not be found.

Plex 2/9/18 12:39 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S057114



Part: RBE105-40001W1-5

Job No: 171958

Serial No/Batch: S057114

Revision: 1

Inspector:

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

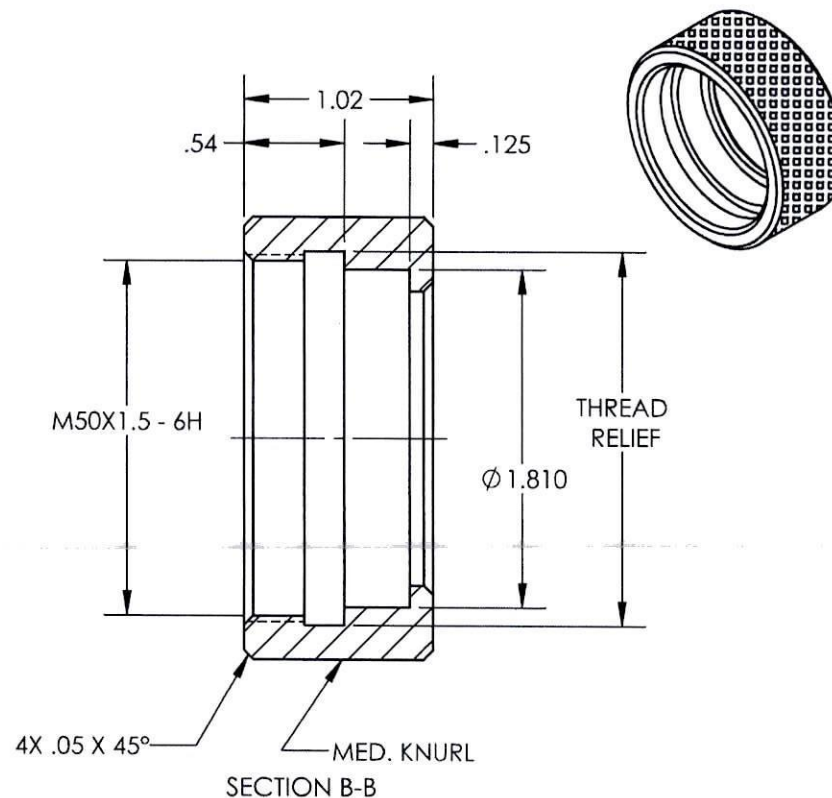
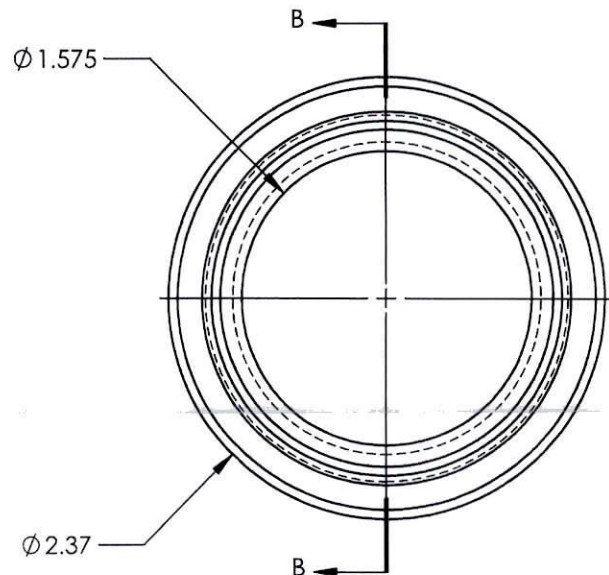
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>B171958</u> Part No. <u>RBE101-40001W1-3/-5/-9</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Date : _____		Step # : _____		QTY Effective : _____		MRB (QSI042) Approval Feb 09, 2018																																																																													
Description Work Order Deviation				Disposition																																																																															
- RBE101-40001W1-3/-5 can be manufactured from 17-4PH-H900 as an alternative material - Heat treat is no longer applicable - Zinc plate is no longer applicable - RBE101-40001W1-9 material call-out is vague, manufacture from M-Delrin-R or MT-Nylon 6-R.				- This deviation is acceptable. - The drawings will be updated to reflect these changes. - The fit, form and function of the tool will be as originally intended.				Completed By																																																																											
								Lead hand / Supervisor Approval Verification																																																																											
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Root Cause <table style="width:100%; border: none;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td></tr> <tr><td>Material</td><td>☒</td><td>Use for Testing</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td></tr> </table>				Environment	☐	No Re-verification	Design	☐	Operator	Doc/Data	☐	Offset/Setup	Equip/Tooling	☐	Supplier	Handling/Pre	☐	Training	Material	☒	Use for Testing	Internal Transport	☐	Poor Information	Tribal Knowledge	☐	Rushing	LOA	☐	Product Improvement	Substation	☐	Process Improvement	Past Expiry Date	☐	Manufacturing Process	Misidentified	☐	Past Due	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td>Pressure/Forced</td><td>Temperature/Cure</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr> <tr><td>Bending</td><td>Set-up</td><td>Folio/Program</td><td>Outside Dimensions</td></tr> <tr><td>Centre Not Concentric</td><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td></tr> <tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Part Incorrect</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>Inspection Incomplete/Unqualified</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr> <tr><td>Cuffs</td><td>Contamination</td><td>Out of Sequence</td><td>Part Moved</td></tr> <tr><td>Crushing</td><td>Countersink</td><td>Off-set</td><td>Drawing</td></tr> <tr><td>Heat Treat</td><td>Cut Too Short</td><td>Mislabeled</td><td>Finish</td></tr> <tr><td>Wave/Twist in Tube</td><td>Instructions Incomplete/Unclear</td><td>Fit/Function</td><td>Misread</td></tr> <tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Misaligned/off center</td><td>Turning Sequence</td></tr> </table>				Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Bending	Set-up	Folio/Program	Outside Dimensions	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Cracks	Broken/Damage/Defect	Weld	Part Incorrect	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing	Cuffs	Contamination	Out of Sequence	Part Moved	Crushing	Countersink	Off-set	Drawing	Heat Treat	Cut Too Short	Mislabeled	Finish	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(5)
RETAINING RING

DART AEROSPACE	
TITLE STAKING TOOL RETAINER	
DWG NO. RBE105-40001W1-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-50	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 12.5
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	SEE SHEET 1 NOTE 2
SCALE 1:1	DATE 1/19/2016
	SHEET 4 OF 6